

Date: Tuesday, 22/04/2008 3:53:18 PM
 User: Julie Lecocq

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	WEB
Job Number	38753			Part Number	D2739
Estimate Number	10498			Drawing Number	D2739 REV D
P.O. Number	..			Project Number	N/A
This Issue	22/04/2008	S.O. No.	:	Drawing Revision	D
Prsht Rev.	NC			Material	:
First Issue	11	Type	LANDING GEAR	Due Date	05/05/2008
Previous Run	38557			Qty:	4
Written By	:			Um:	Each
Checked & Approved By	JLD 08-4-23				
Comment	Est Rev: C 02.11.28 Reformat KJ Est Rev: D 06-03-21 As Per Rev C JLM Est Rev: E 07-07-28 As per Rev D JLM Verified By:				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	D26005108	Extrusion 'I Beam' thin
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Extrusion 'I Beam' thin Pick: Qty Part Number Description Batch 1 D2600-5 Web 29985		
2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
Comment: LANDING GEAR RESOURCE 1 1-Cut D2600-5 to length as per Dwg D2739. <i>AT</i> 08-04-29 2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 <i>AT</i> 08-04-29 3-Use uni-bit to open holes to finish size as per Dwg D2739. <i>AT</i> 08-04-30 4-Bevel Fwd end of extrusion and Deburr holes and ends. <i>AT</i> 08-04-29 5-Dburr <i>AT</i> 08-04-30		
3.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <i>DP 8-4-30</i> <i>(4)</i>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

4.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

DT 08-04-30 x4

5.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 08-04-30 60

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock

Location: skid tube cell

RT 08-04-30 x4

7.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/01 g/f

Job Completion



mf 08-04-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

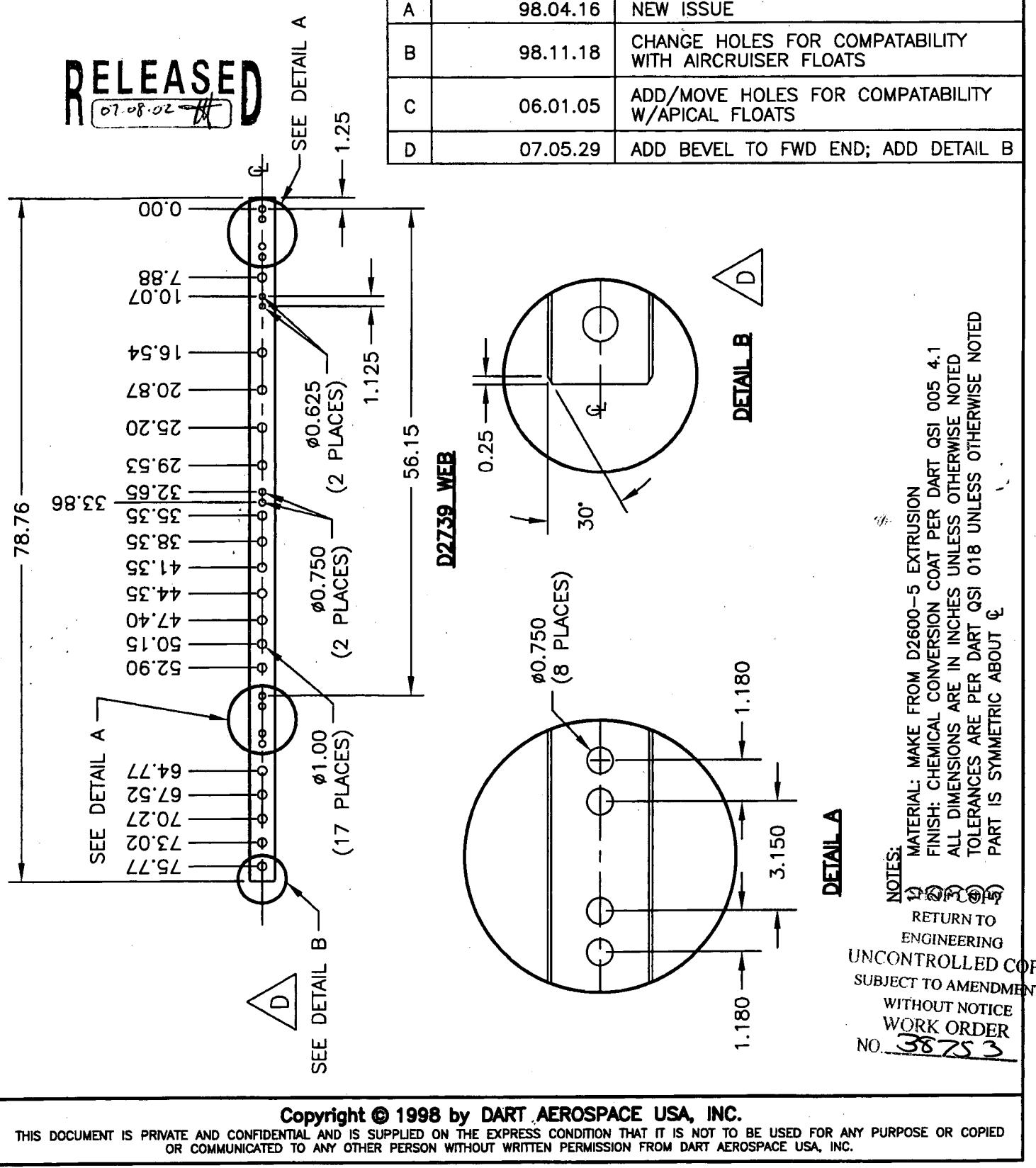
NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA		
CHECKED PH	APPROVED TH	DRAWING NO. D2739	REV. D SHEET 1 OF 1	
DATE 07.05.29		TITLE WEB	SCALE 1:15	
A	98.04.16	NEW ISSUE		
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS		
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS		
D	07.05.29	ADD BEVEL TO FWD END; ADD DETAIL B		

RELEASER
07.08.02 - *[Signature]*

07.08.02 ~~ff~~



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